

539

DART AEROSPACE LTD.	Work Order:	24202
Description: 206 Saddle, Outboard, Left Side	Part Number:	D2665-1
Drawing: D2665 Rev B	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Dwg. not required RF 02/09/16	SP	05/09/06	8
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (B6101-003) RF 02/09/16 Batch No: B22241	EP	05/09/27	8
3	HAAS	Program batch number.	EP	05/09/27	8
4	QC	Inspect part number and batch number are programmed correctly.	ML	05/09/27	8
5	HAAS	Fixturing W/O No. <u>MA</u> Fixturing Inspection last completed on 05/09/27 by EP	EP	05/09/27	8
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	EP	05/09/28	8
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	EP	05/09/28	8
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	EP	05/09/29	8
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	EP	05/09/28	8
12	METAL	Deburr	EP	05/09/28	8
13	HAAS	Inspect Level 1	EP	05/09/28	8
14	QC	Inspect Level 8	ML	05/09/28	8
15	METAL	Acid etch and Alodine as per QSI 005 4.1	ML	05/10/28	8
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	ML	05/10/28	8
17	QC	Inspect Level 3	CL	05/10/28	8
18	STORES	Pack in foam, identify and stock.	PO	05/10/28	8
19	EXPEDITING	Close Work Order Job Cost / Part 25.98 545 05/10/27	CL	05/10/27	8

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	

RELEASED

DEC 18 2000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24202
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.128	0.128	0.127	0.127		
B	0.100	0.140		0.126	0.127	0.128	0.129		
C	0.100	0.140		0.125	0.127	0.130	0.126		
D	0.210	0.230		0.223	0.224	0.226	0.225		
E	1.245	1.255		1.249	1.247	1.247	1.248		
F	1.245	1.255		1.249	1.247	1.247	1.248		
G	5.990	6.010		6.002	6.002	6.001	6.000		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.677	1.677	1.678	1.678		
J	2.495	2.505		2.498	2.500	2.499	2.499		
K	0.257	0.262	DT8683		✓	✓			
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.239	0.240	0.240	0.237		
N	0.100	0.140		0.118	0.120	0.117	0.117		
O	0.540	0.560		0.543	0.547	0.546	0.545		
P	0.490	0.510		0.499	0.494	0.494	0.492		
Q	3.609	3.619		3.611	3.612	3.611	3.610		
R	2.470	2.510		2.499	2.499	2.495	2.496		
S	0.240	0.270		0.253	0.254	0.253	0.253		
T	0.100	0.180		0.137	0.140	0.138	0.140		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.138	1.138	1.137	1.137		
W	1.565	1.585		1.577	1.578	1.578	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	GP
Date:	05/08/28

Audited by:	gm
Date:	05/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

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Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.128	0.127	0.127	0.129		
B	0.100	0.140		0.128	0.129	0.128	0.130		
C	0.100	0.140		0.126	0.128	0.128	0.125		
D	0.210	0.230		0.227	0.227	0.225	0.225		
E	1.245	1.255		1.248	1.248	1.248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1.248		
G	5.990	6.010		6.001	6.000	5.999	6.003		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.677	1.675	1.678	1.677		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.119	0.108	0.119	0.117		
O	0.540	0.560		0.545	0.545	0.545	0.546		
P	0.490	0.510		0.493	0.494	0.493	0.498		
Q	3.609	3.619		3.612	3.611	3.611	3.611		
R	2.470	2.510		2.497	2.495	2.498	2.499		
S	0.240	0.270		0.254	0.254	0.253	0.252		
T	0.100	0.180		0.143	0.145	0.139	0.137		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.138	1.137	1.138	1.137		
W	1.565	1.585		1.575	1.576	1.577	1.575		
X									
Y									
Z									
AA									
AB									
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AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EO
Date:	05/09/28

Audited by:	gml
Date:	05/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 02, 2005
09:01 am

Work Order No : 0024202
Project Name : D2665-1
Project For : WK539
Work Order Type : Main
Main WO Number :
House Part Number : D2665-1
Description : Saddle, LH Fwd Aft Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 09-01-05
Est Finish Date : 09-29-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0. Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00